

Date: Monday, 9/10/2007 1:32:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING	
Job Number	: 34524				
Estimate Number	: 10089				
P.O. Number	: N/A		Part Number	: D312123	
This Issue	: 9/10/2007 S.O. No. : N/A		Drawing Number	: D3121 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: D	
Previous Run	: 32170		Material	: N/A	
Written By			Due Date	: 9/17/2007	
Checked & Approved By			Qty:	40	Um: Each
Comment	: Est. A: 04.02.19 New Issue KJ/DS				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		Comment: PURCHASING Issue P/O: <u>4555</u> Bearing as per Dwg D3121 Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-ZZ Material release note is required
2.0	6900ZZ	Bearing 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Bearing
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK  
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev <u>D3121-23</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST66</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/09/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:32:14 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 34524

Part Number: D312123

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

10/09/14

Job Completion



10/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

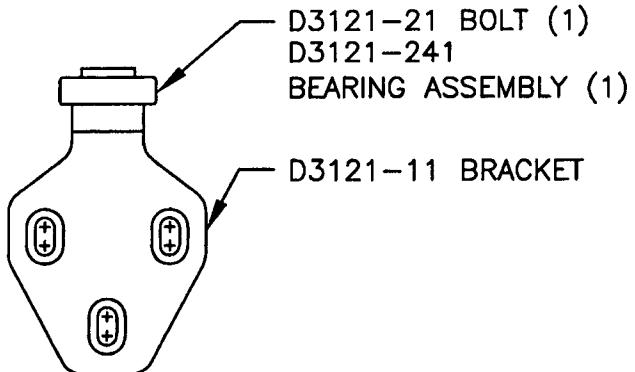
NOTE: Date & initial all entries

**DART**

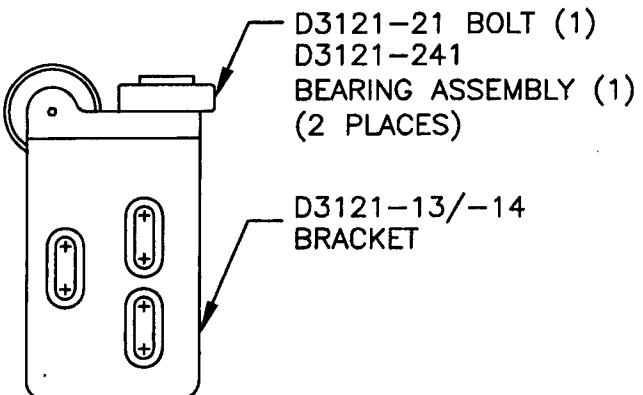
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121
DATE		REV. D SHEET 1 OF 10
06.05.17		TITLE SCALE BRACKET ASSEMBLY 1:2

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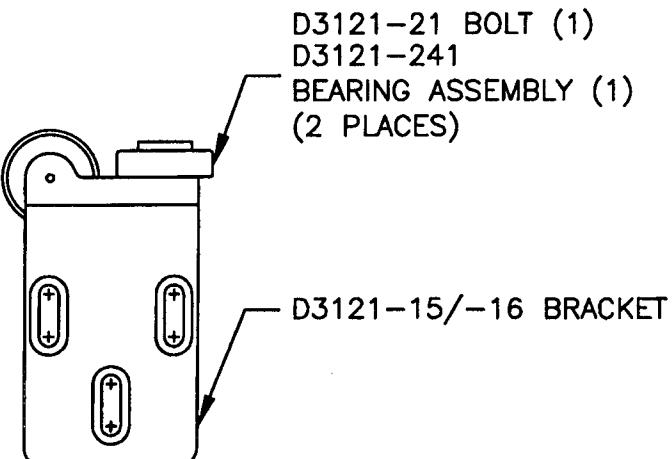
06.06.02



**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

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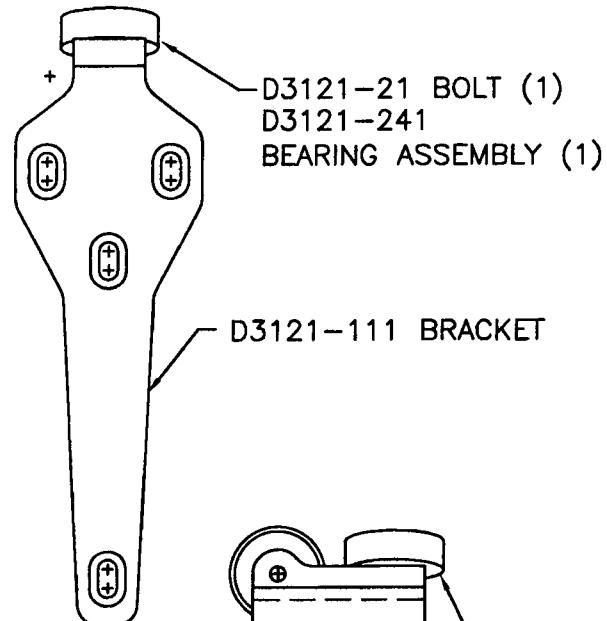
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DATE	06.05.17	TITLE BRACKET ASSEMBLY

REV. D

SHEET 2 OF 10

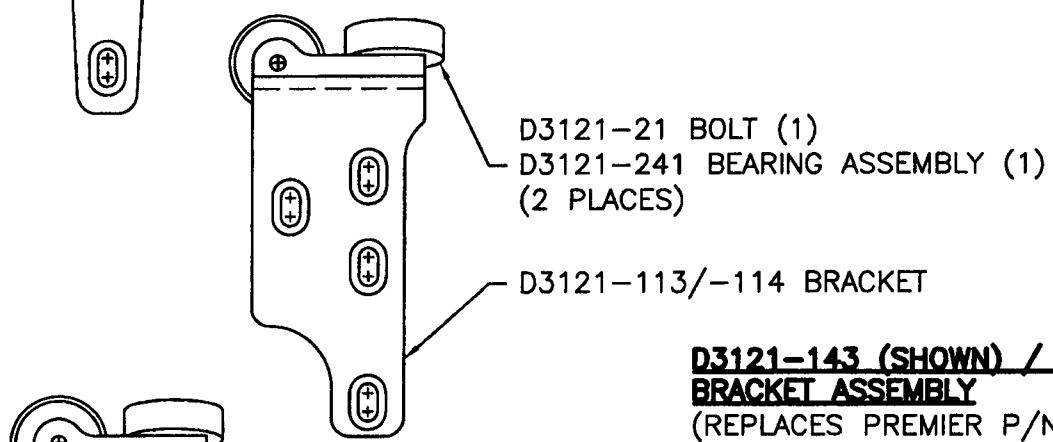
1:2



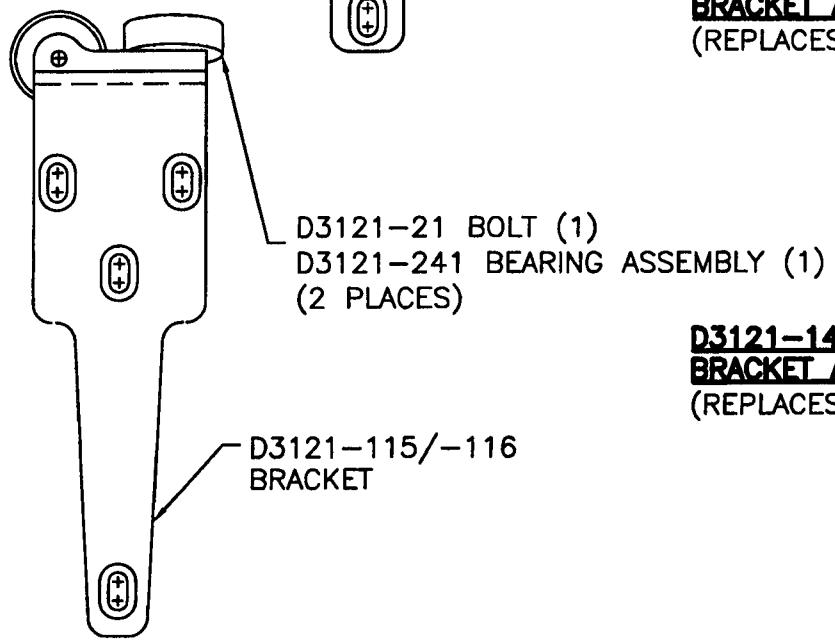
**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

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06.06.02



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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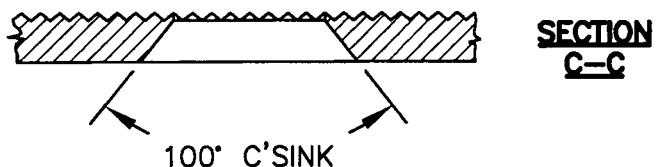
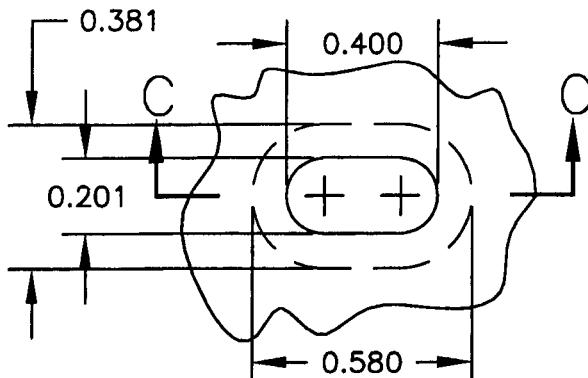
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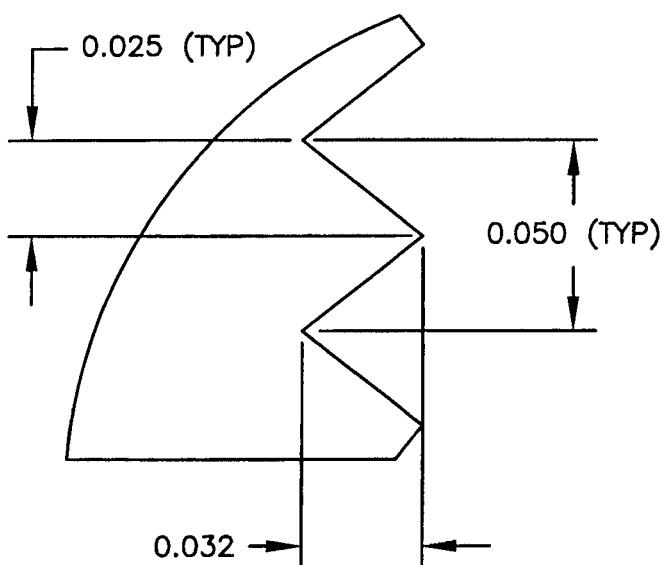
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		D3121	SHEET 3 OF 10
DATE	TITLE	SCALE	1:1
06.05.17	BRACKET ASSEMBLY		

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



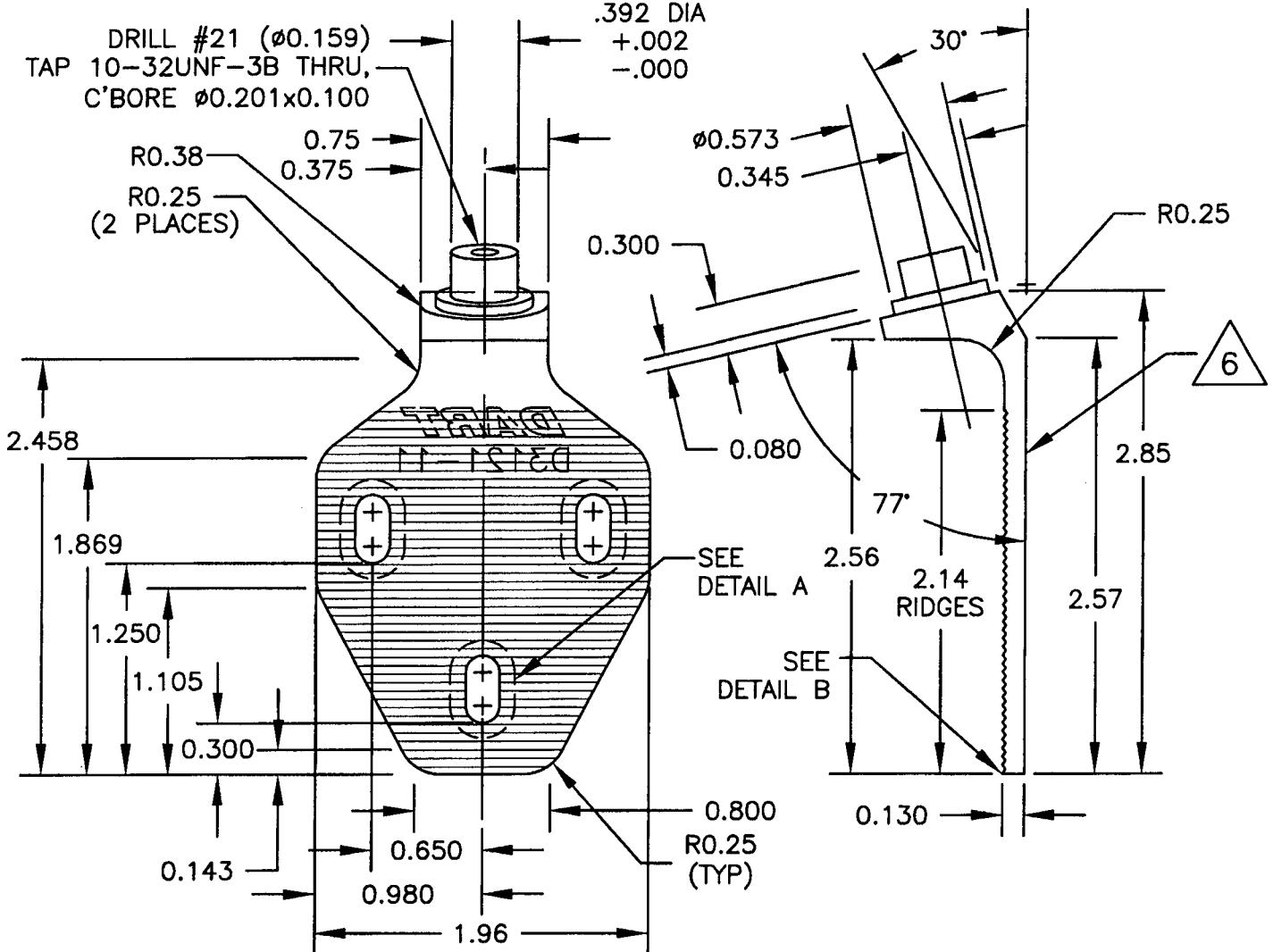
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S. J. H.	M. H.	D3121	REV. D
DATE	TITLE	SHEET 4 OF 10	1:1
06.05.17	BRACKET ASSEMBLY		

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

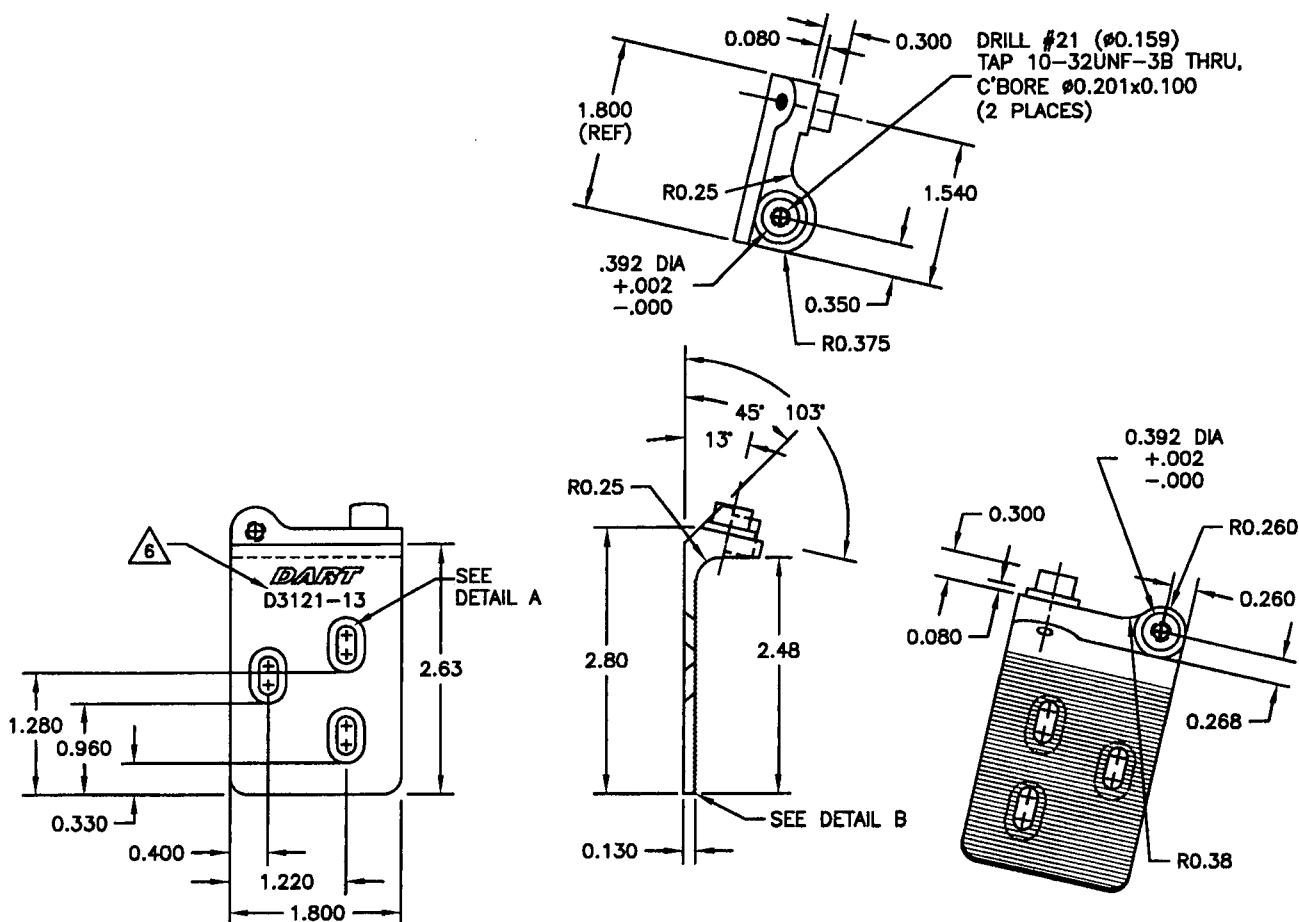
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		D3121	SHEET 5 OF 10
DATE	TITLE	SCALE	1:2
06.05.17	BRACKET ASSEMBLY		

**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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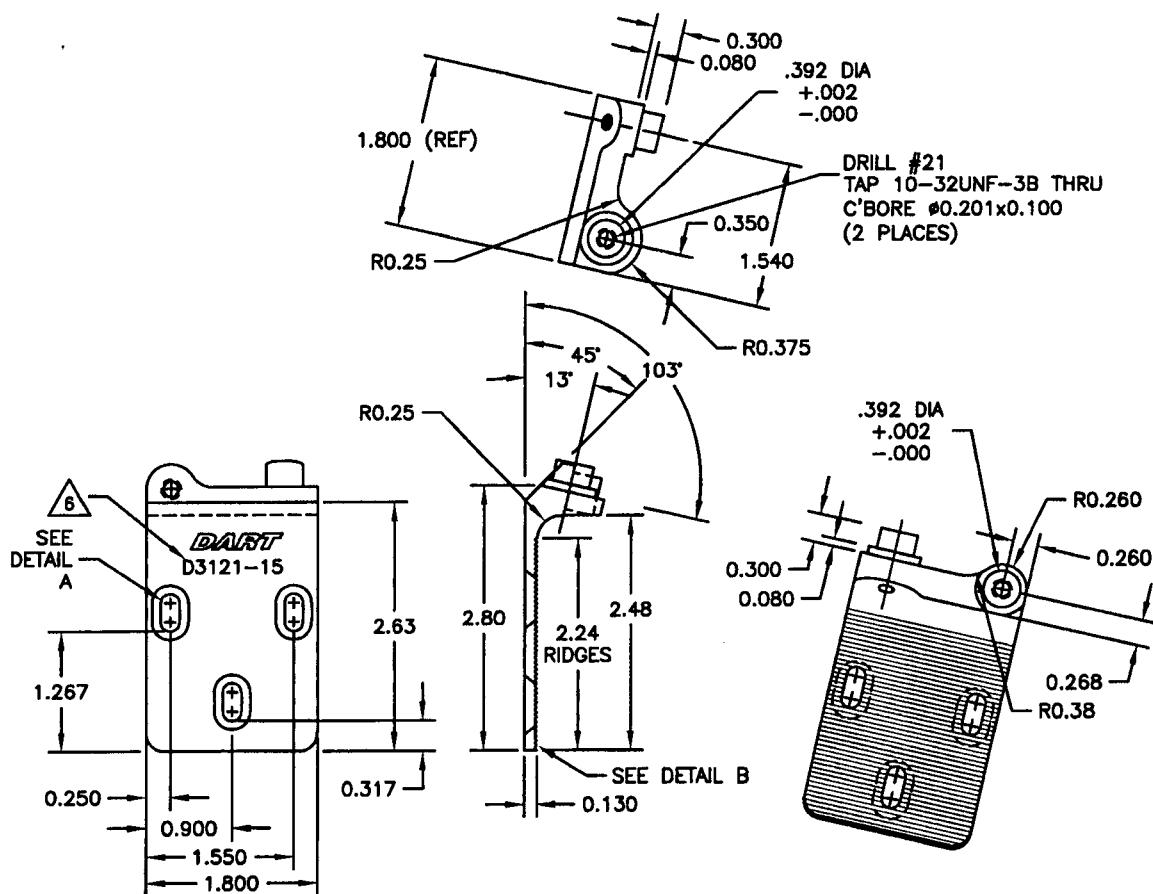
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		D3121	SHEET 6 OF 10
DATE	TITLE	SCALE	1:2
06.05.17	BRACKET ASSEMBLY		

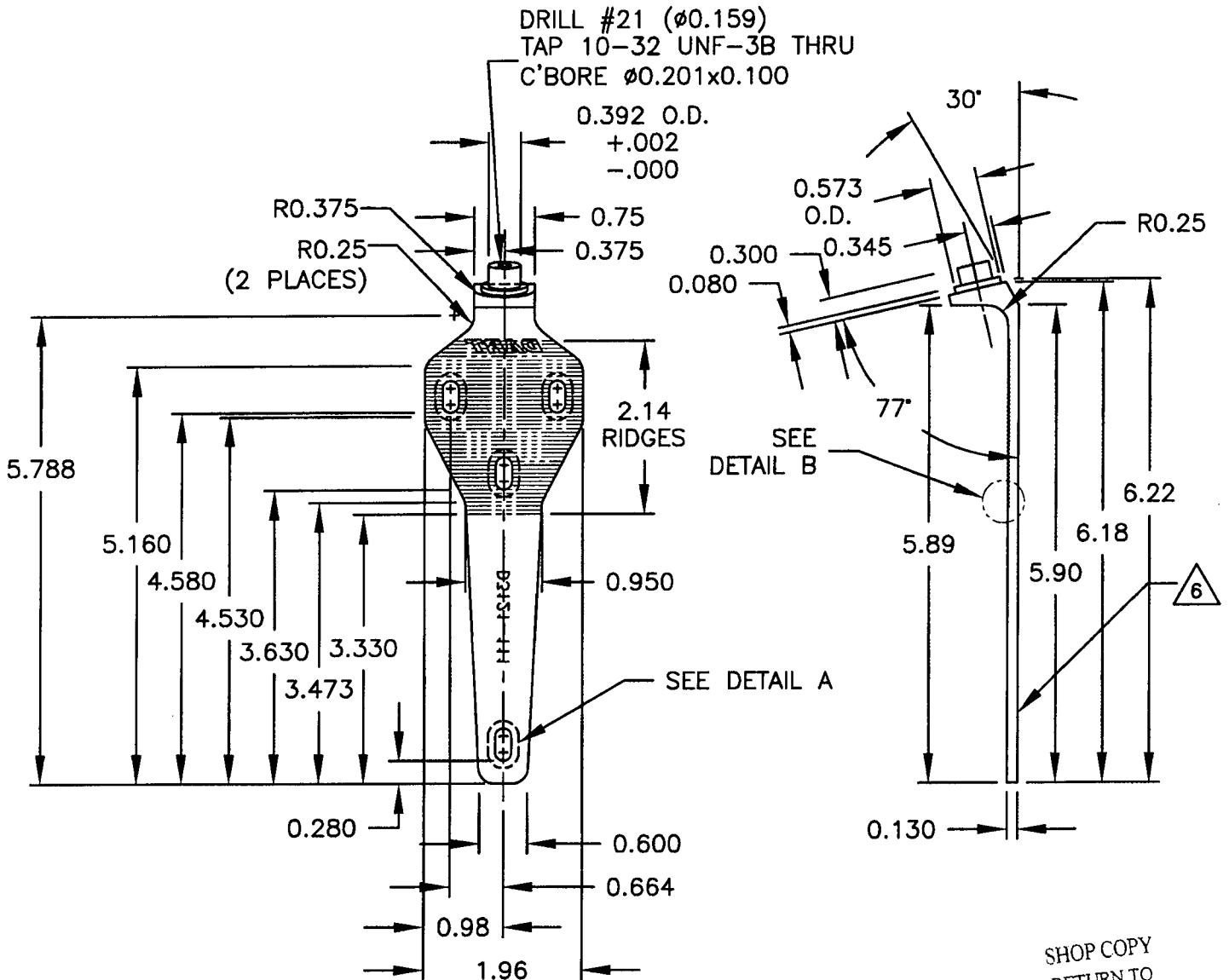
**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

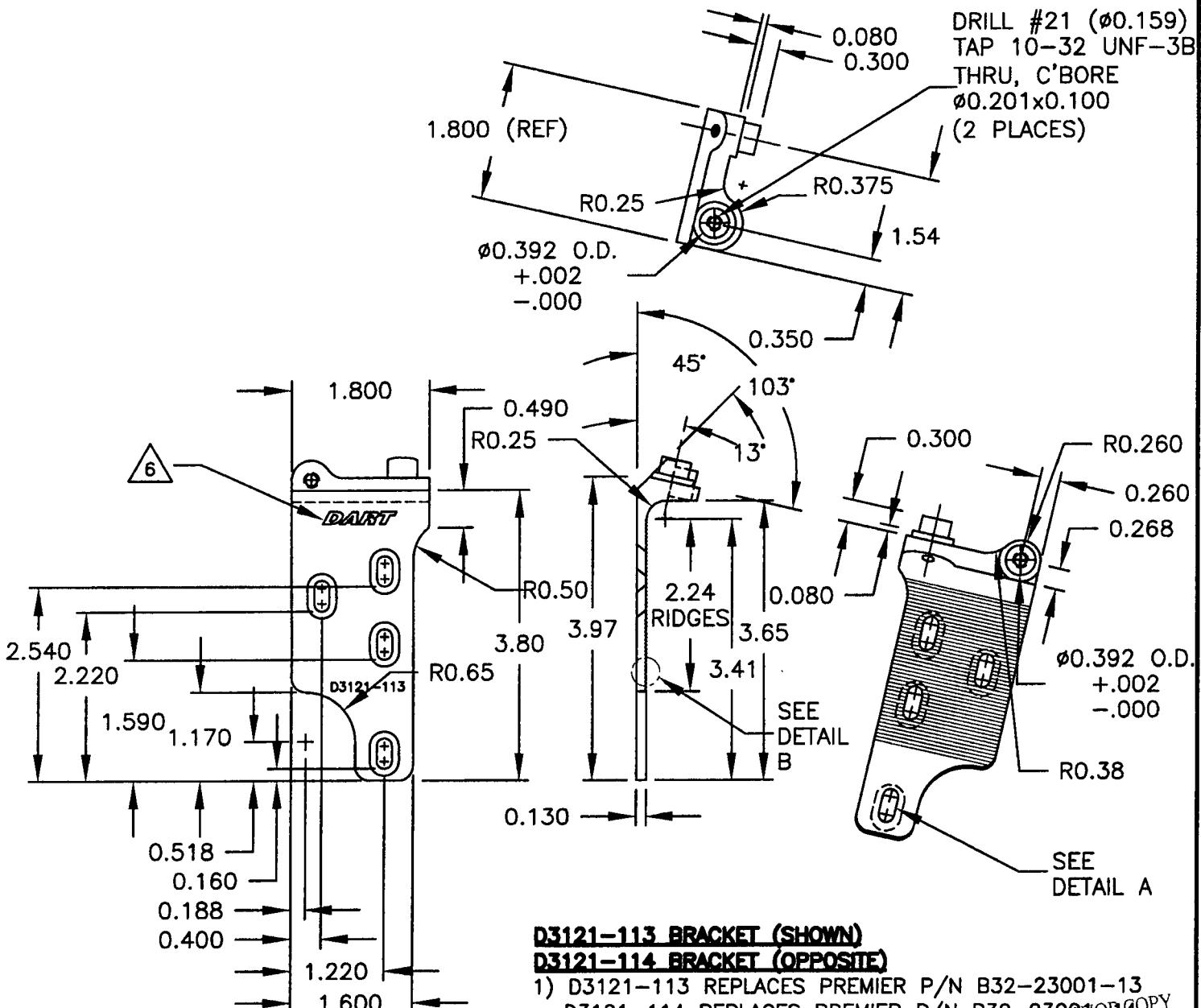
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**D3121-113 BRACKET (SHOWN)**  
**D3121-114 BRACKET (OPPOSITE)**

1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14 COPY

2) MATERIAL: 17-4 SS PER AMS 5604/5643 RETURN TO  
(REF DART SPEC. M17-4-B) ENGINEERING

MIN ULTIMATE TENSILE STRENGTH = 150 ksi ASKILED COPY

MIN YIELD TENSILE STRENGTH = 100 ksi SUBJECT TO AMENDMENT

3) TOLERANCES ARE PER DART QSI 018 UNLESS WITHOUT NOTICE  
OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES WORK ORDER

5) BREAK ALL SHARP EDGES 0.005 TO 0.015 NO 34524

6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASED

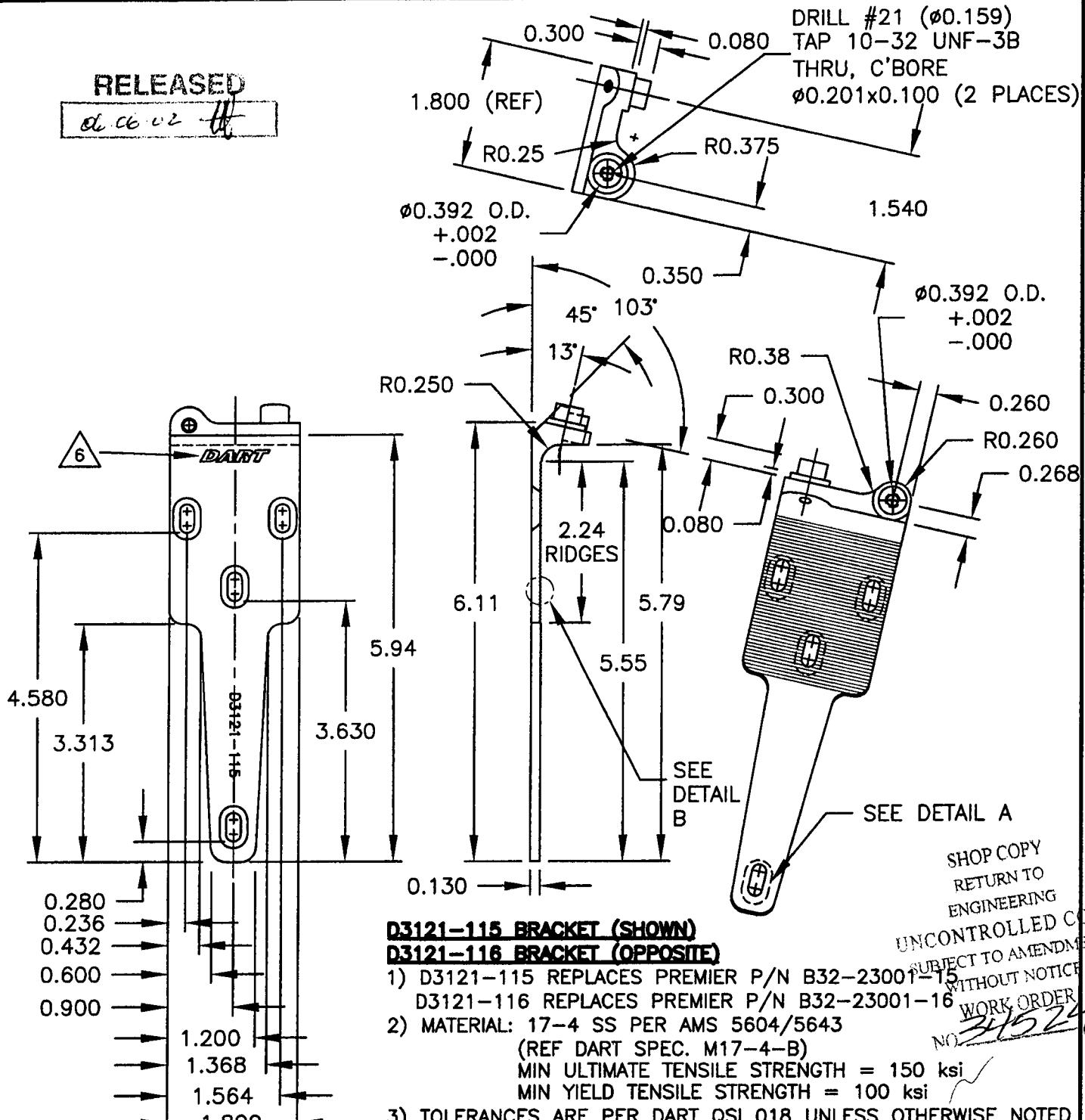
06.06.02 ~~th~~

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		D3121	SHEET 9 OF 10
DATE		TITLE	SCALE
04.02.18		BRACKET ASSEMBLY	1:2

RELEASED

06.06.02

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

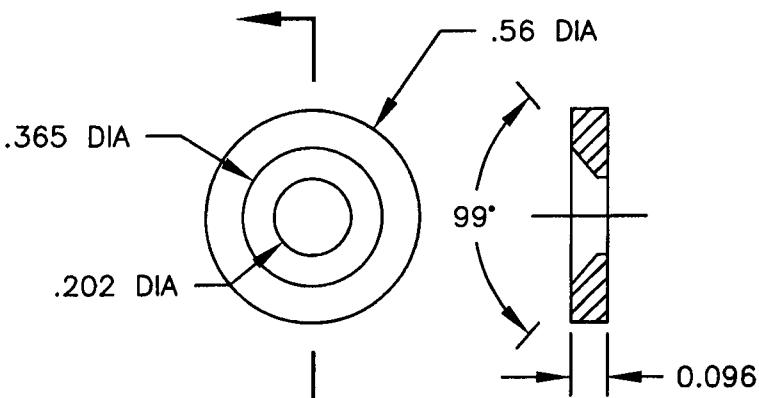
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WORK ORDER  
NO. 34524

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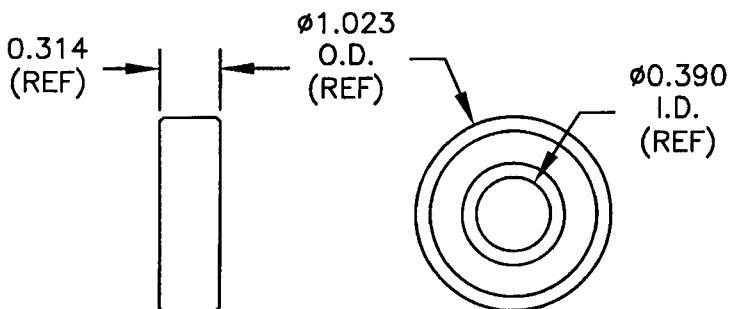
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S. J. H.		D3121	SHEET 10 OF 10
DATE	TITLE	SCALE	1:1
06.05.17	BRACKET ASSEMBLY		



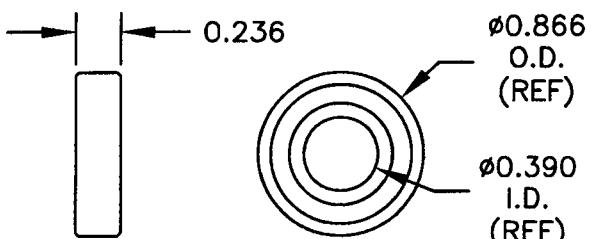
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



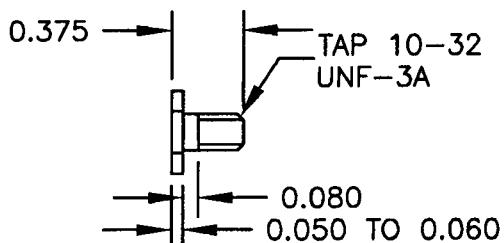
#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



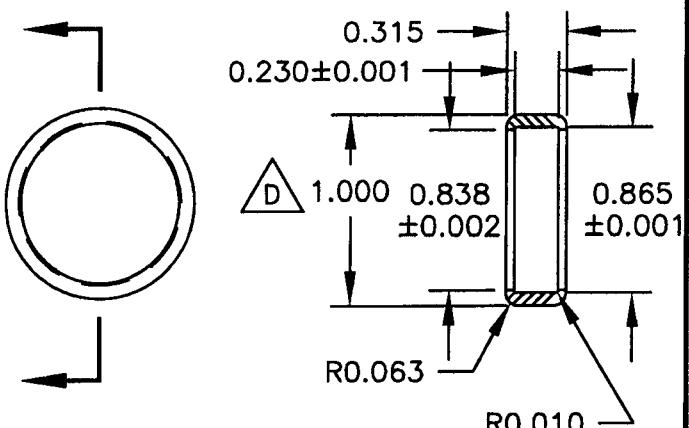
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



#### D3121-21 BOLT (SCALE 1:1)

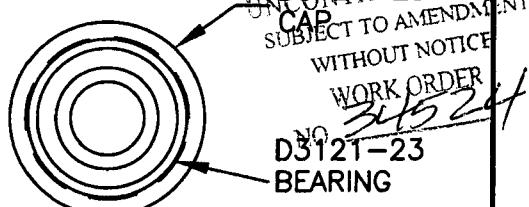
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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#### D3121-241 BEARING ASSEMBLY (SCALE 1:1)



cle

# GENERAL BEARING SERVICE

Inc.

[www.gbs.ca](http://www.gbs.ca)

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979094

ORDER DATE: SEP 13, 2007

SOLD TO: DART AEROSPACE LTD.  
1270, ABERDEEN STREET  
HAWKESBURY, ON.  
K6A-1K7

SALE MODE: JV: LB  
CUSTOMER ORDER #: 04555  
SHIP VIA: DICOM H29 996 551

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6900-2Z	BALL BEARING	48	40	4.97	198.88 6.S.T. 11.93

*8/13/07* *9/13/07*

PACKING SLIP NO: 462239-0

RECEIVED BY: \_\_\_\_\_

0001459

**DART****Purchase Order**

Date Sep 11, 2007	Page 1
Purchase Order Number PO00004555	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FAXED****Vendor Address:**

General Bearing Service  
386 Main Street  
Hawkesbury, ON K6A 1A5  
Phone (613) 632-9914  
Fax (613) 632-2751

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury, Ontario K6A 1K7

Preference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-GEN001	Sep 11, 2007	N30	yours	Sep 13, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
40.0000	6900ZZ	Bearing Comments: AS PER DWG D3121 REV. D P/N: 61900-2 OR KML P/N: 6900ZZ	9/13/2007	No			

Comments:

**Tax Summary:**  
GST  
GSTME  
GSTND

**Less:**  
included tax

Entered By: *CL* CLAVOIE**Subtotal**Approved By: *J***Total tax**

**Total purchase order in**  
CAD Dollars

